

Date: Thursday, 07/05/2009 8:40:07 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 212 X-TUBE ,LOW STANDARD AFT
Job Number : 47783	
Estimate Number : 13019	
P.O. Number :	Part Number : D212664207
This Issue : 07/05/2009 S.O. No. :	Drawing Number : D212-664-247
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : CROSSTUBES	Drawing Revision : A
Previous Run : 47782	Material :
Written By :	Due Date : 27/05/2009 Qty: 1 Um: Each
Checked & Approved By : JLD 09-05-07	
Comment : Est Rev:A New Issue 07.09.12 EC verified by: JLM Est Rev:B ECN 1100p 08-01-11 DD verified by: EC Est Rev:C ECN 1121 08-02-25 DD verified by: eC Est Rev: D QC5 replaced by QC15 at step 5 KJ Verified by: ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JLD 09/05/22

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-207 CHG001

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

3.0	D212664207TRN	Crosstube Turning Detail
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch B-47783 ✓

MB

09-05-07

⑦

4.0	BENDING	BENDING MACHINE - SKIDTUBES
-----	---------	-----------------------------



MB

09-05-07



①

Comment: BENDING MACHINE

Bend tube as per Dwg D212-664-247 using CNC bender program and Folio FT

5.0	QC15	DIMENSIONAL CHECK OF X-TUBES
-----	------	------------------------------

**Comment:** DIMENSIONAL CHECK OF X-TUBES

S 09/05/08 ②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 47783

Part Number: D212664207

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D36601

CUFF



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

CUFF

Batch: B-44455

MB

09-05-08

(2)

7.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill Rivet holes as per Dwg D212-664-247 using DT8972.

2-Drill pilot holes in tube as per Dwg D212-664-247 using DT8550 and DT8551

3-Ream hole to finish size in tube as per Dwg D212-664-247

4-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-247

4-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-247

09-05-12

AWM 9-5-12

-RT 09-05-12

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat Tube & Cuffs as per QSI 005 4.1

AWM 9-5-12

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09/05/13 (4)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/05/13 (4)

11.0

OUTSIDE SERV.11

OUTSIDE SERVICE -CROSSTUBES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038

Issue P/O: 8800 LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

C209/05/13 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 X-TUBE ,LOW STANDARD AFT

Job Number: 47783

Part Number: D212664207

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

0209/05/13 (1)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect for damage & ensure results are as per Dwg D412-664-203

ml 09 05 13

(1)

14.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Rivet Cuffs as per Dwg D212-664-247. with Sika flex in Between tube & Cuff

A/R SIKAFLEX -241/-291 BATCH: ml 111081

ml 09.05.14 (1)

15.0

CR3212406

CHERRY RIVET



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

CHERRY RIVET

Batch: 107534

ml 09.05.14

16.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

PRIME:

Start Time: 9:45

Finish Time: 11:45

ml 09 05 14 (1)

PAINT:

Start Time: 3:15

Finish Time: 4:30

ml 09 05 14 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: 212 X-TUBE ,LOW STANDARD AFT

Job Number: 47783

Part Number: D212664207

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

3505-20 ①

18.0

D29401

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Support

batch: 41536

ml 09 05 20

19.0

D3595063530

RUBBER CUSHION



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Rubber Cushion

Batch: 40780

ml 09 05 20

20.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Clamp

Batch: 109965

ml 09 05 20

21.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Assemble as per Dwg D212-664-247

2- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

3- Instal support with magnobond 6398 per dwg D212-664-247,
cure for 12hrs before packaging.

Time & date of application: 11:45 am

Batch: 111249

EXP. DATE 02/2010

ml 09 05 20 ①

Torque: 80-100

ml 09 05 21 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 47783

Part Number: D212664207

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7/5/22 (1)

23.0

AN640A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch M111421

9/8/22

SP

24.0

AN641A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch M109391

9/5/22

SP

25.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

batch M110002

9/5/22

SP

26.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

batch M111193

9/8/22

SP

27.0

D34281

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

batch B45182

9/5/22

SP

28.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

7/5/22 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 47783

Part Number: D212664207

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and pack for shipping as per PPP D212-664-207

Rev A 09/05/22

30.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/22

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



09.05.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

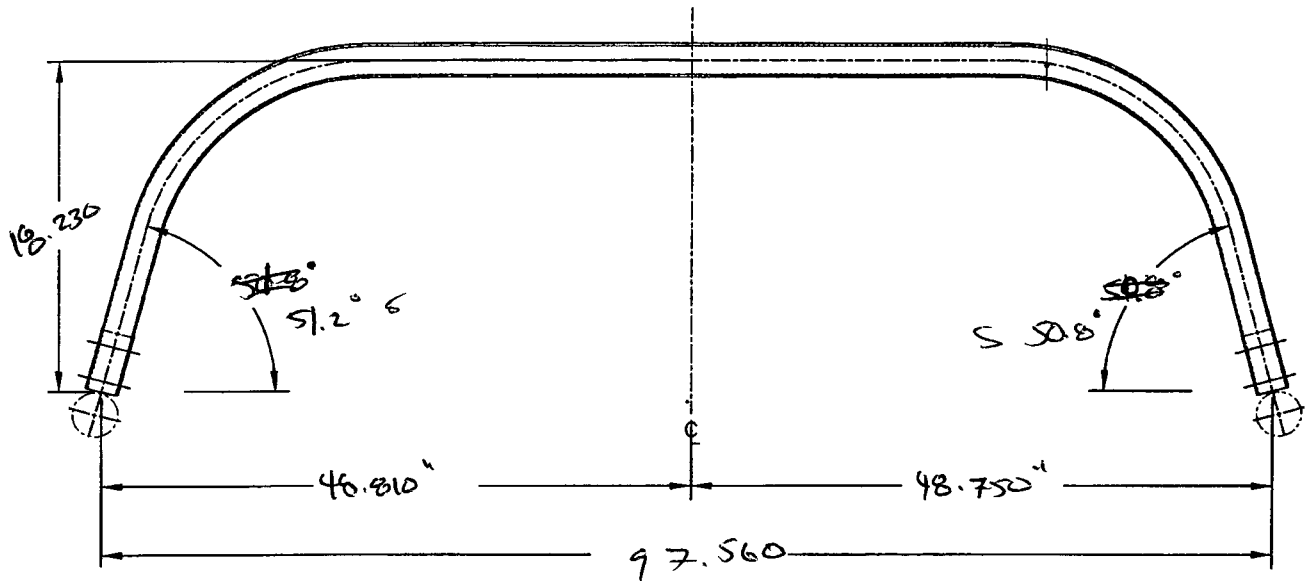
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	47783
Description: Crosstube Low Aft (205/212)		Part Number:	D212-664-207
Inspection Dwg: D212-664-247 Rev: A		Page 1 of 1	

Required Dimension	Min	Max
Height	18.16	18.42
1/2 Span	48.55	48.81
Angle	49	52
Total Span	97.1	97.62



Comments

QC15 Inspection	S
Date	01/05/08

Rev	Date	Change	Revised by	Approved
A	08.02.29	New Issue	KJ/JM	[Signature]

PARTS LIST:

Qty	Part Number	Description
X	D212-664-247	CROSSTUBE ASSEMBLY (205/212 LOW AFT)
1	D6008-132	CROSSTUBE
2	D2940-1	SUPPORT
4	D3595-063-530	RUBBER CUSHION
2	D3660-1	CUFF
4	MS21920-28	CLAMP (OR MS21920-30)
44	CR3212-4-06	RIVET (OR M7885/3-4-06)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
A/R	SIKAFLEX-241/-291	SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6008-132
FINISHED LENGTH = 128.27±0.020 (BEFORE BENDING/TRIMMING)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRIC ABOUT CENTERLINE.
- 6) WHEN MACHINING TAPER, RUN-OFF PART AT STOCK. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 7) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D., EXCEPT UP TO 10% IS ALLOWED IN AREA NOTED.
- 8) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 9) SCRIBE DART PART NUMBER AND BATCH NUMBER ON INNER SURFACE OF TUBE WITH A VIBRATING STYLUS.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2940-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-28 CLAMPS (OR -30) WITH D3595-063-530 RUBBER CUSHIONS TO SECURE D2940-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- 14) INSTALL D3660-1 CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT, WITH A LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN CUFF AND CROSSTUBE. SEAL EDGE OF CUFF TO ENSURE NO GAPS.
- 15) TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT.

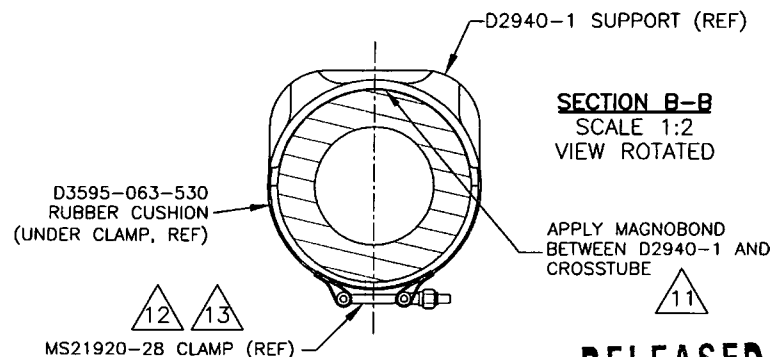
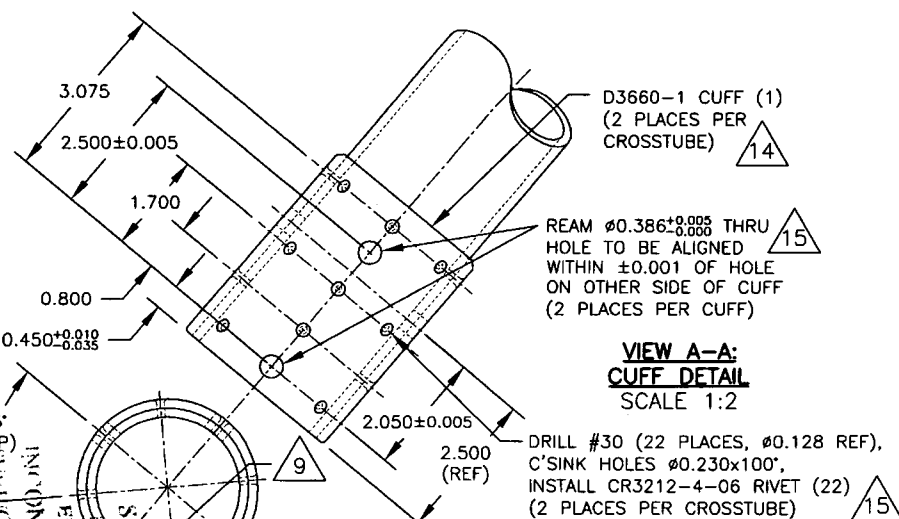
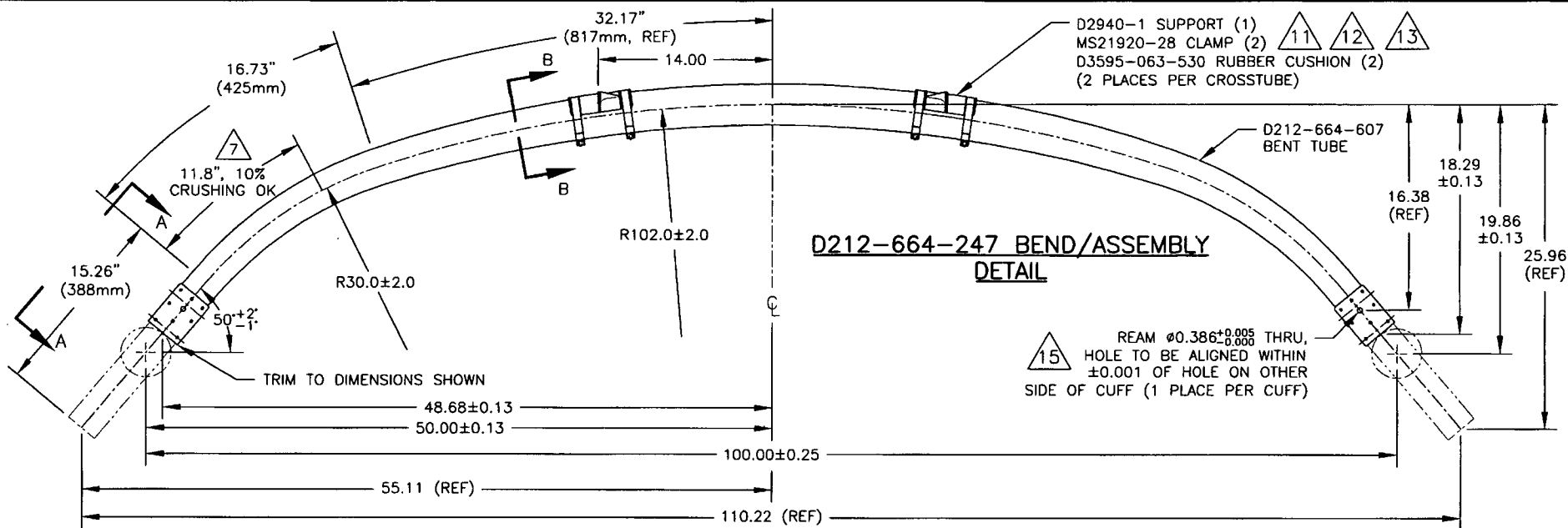
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07.07.07

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WITHOUT NOTICE
WORK ORDER
NO 4785

A	07.07.07	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. REV. A D212-664-247 SHEET 1 OF 3
DATE	TITLE	SCALE
07.07.07	CROSSTUBE (205/212 LOW AFT)	NTS

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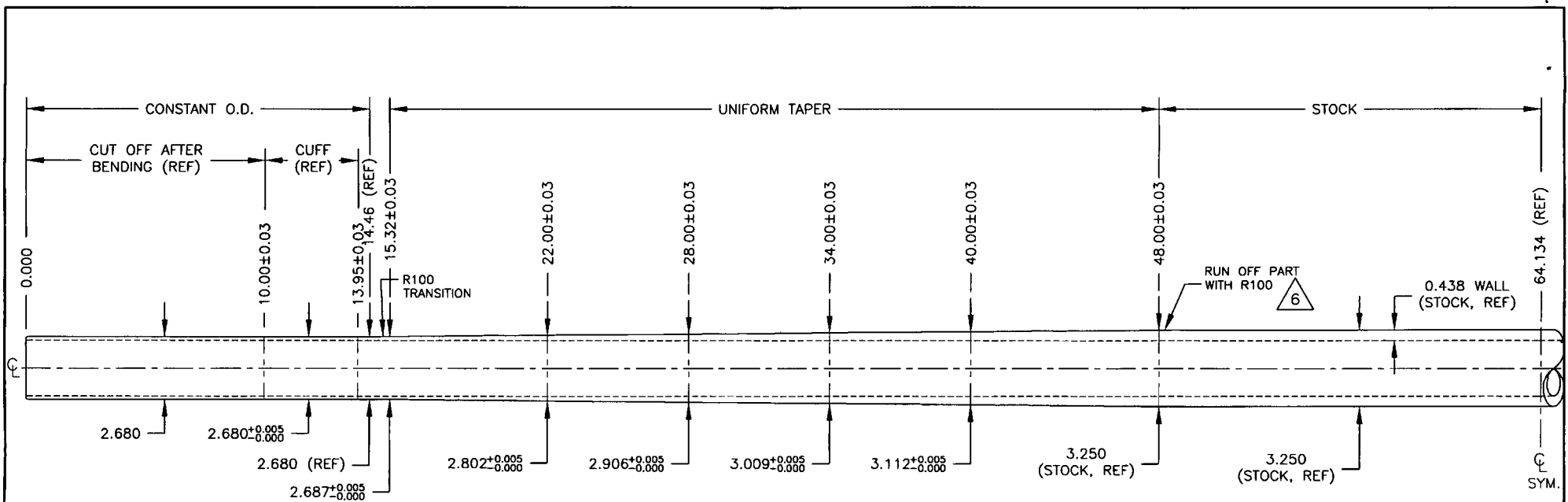
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		DATE		D212-664-247	SHEET 2 OF 3
		07.07.07		TITLE	SCALE
				CROSSTUBE (205/212 LOW AFT)	1:8

NO. 21283
ENGINEERING
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D212-664-247 MACHINING DETAIL

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07.04.24

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DATE 07.07.07		TITLE CROSSTUBE (205/212 LOW AFT)		SCALE 1:4	



LIQUID PENETRANT TEST REPORT

P- 08828

CLIENT DAVE KERO SPACE DATE MAY 13, 2009 PAGE 1 OF 1
ATTENTION LINDA / CHANTEL ACUREN JOB NO. 188-09-001401 TIME AM ☒ PM ☐
ADDRESS 1270 ABERDEEN ST. POWO No. 8800
HAWKESBURY, ONT. K6A 1K7 WORK LOCATION MAW SHOP - HAWKESBURY
ACCEPTANCE STD. ASTM 1417 REV./DATE 2007
PROJECT F.P.T. ON CROSS TUBES
ITEM(S) EXAMINED 4 CROSS TUBES - 100% EXTERNAL

JOB DESCRIPTION PROCEDURE No. LT-XXXX REV./DATE TECHNIQUE No. LT-XXXX-XXX REV./DATE
PART No. MATERIAL ANODIZED ALUMINUM THICKNESS —
SCOPE WET FLUORESCENT LIQUID PENETRANT INSPECTION
CARRIED OUT ON 100% EXTERNAL.

TEST DETAILS
METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
FAMILY BRAND MAGNAFLUX BLACK LIGHT S/N 8171 ☐ OUTPUT > 1000 μ W/cm² ☐ AMBIENT < 2 fc
PENETRANT 2LG7 MINIMUM DWELL TIME 15 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER H2O MINIMUM DRY TIME >10 MIN. OTHER
DEVELOPER SKD 50 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N CAL DUE DATE FEB 2010
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE
SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☐ MACHINED ☐ SHOT BLASTED ☐ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/50°F ☐ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- <input type="checkbox"/> METRIC <input type="checkbox"/> IMPERIAL			
ITEM	COMMENTS	ACCEPT	REJECT
	<u>JOB NUMBER.</u>		
1-	<u>47778</u>	<input checked="" type="checkbox"/>	
1-	<u>47779</u>	<input checked="" type="checkbox"/>	
1-	<u>47782</u>	<input checked="" type="checkbox"/>	
1-	<u>47783</u>	<input checked="" type="checkbox"/>	
<u>THESE ITEMS HAVE BEEN FOUND ACCEPTABLE</u>			

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.
Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES
CLIENT REPRESENTATIVE MATT MURDOCH Matt Murdoch DTR # E-27916
TECHNICIAN (SIGNATURE): Mike Houston Mike Houston
NAME (PRINT): Mike Houston 1ST TECHNICIAN 2ND TECHNICIAN
CGSB LEVEL 2 SNT LEVEL — CGSB LEVEL — SNT LEVEL —
CGSB REG. NO. 6666 CGSB REG. NO. —